

Date: Friday, 01/08/2008 3:28:51 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services.	Drawing Name	: SLIDE BAR
Job Number	: 40938	Part Number	: D30111
Estimate Number	: 11085	Drawing Number	: D3011 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 01/08/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 15/08/2008
Previous Run	: 33335	Qty:	12 Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 08.8.05</u>		
Comment	: Est. C 02.05.09 Added D6202 at step 2 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6202	I-Beam Extrusion
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Comment: Qty.: 1.0000 f(s)/Unit Total : 5.0000 f(s)

I Beam Extrusion

Material: 6061-T6 (QQ-A-200/8)

"I" Beam Extrusion 4" x 2.796" x 0.326"

Batch B 37669

DTP 08/08/08

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks: 26.57"

DTP 08/08/08

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Ensure Batch Number programmed matches this W/O

Machine as per folio FA129

PD →

Jul 1 JL 08/08/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

28 08/08/11

11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: 08-024 Fault Category: Prod / MACHINE ^{PARTS} NCR: Yes ☒ No ☐ DQA: S Date: 08/08/14
 QA: N/C Closed: _____ Date: _____

NCR: <u>N/A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/6/14</u>	<u>30</u>	<u>Parts machines with out offset Dim 2.125 is 2.113</u> <u>RC Program error</u>	<u>CP</u> <u>08.08.11</u> <u>PL</u> <u>08/04/14</u>	<u>Fix Program as per PAR 08-24</u> <u>SCRAP and Destroy and no Replace</u>	<u>[Signature]</u> <u>08/08/14</u>	<u>8.11</u> <u>[Signature]</u> <u>8/6/14</u>	<u>CP</u> <u>08.08.11</u> <u>PL</u> <u>08/04/14</u>	<u>[Signature]</u> <u>8/6/14</u>

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:28:51 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDE BAR

Job Number: 40938

Part Number: D30111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

11 / 92

08.08.11

(11)

7.0

POWDER COATING

POWDER COATING



M108523



(11X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:45
320°F
1:15

m.h. 08/08/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



95



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-12

(11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

R.P. 40890 + 41027 (Assembly)

AS 08/08/13

(11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/14

Job Completion



u 08-08.14.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/08/08	3.0	Part machined with out offsets → dim. 2.125 is off (2.110) DIP 08/08/08 1 Programme was fixed. PR# 08-24					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46938
Description: Rappel Slide Bar		Part Number: D3011-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.32	$\pm .030$	26.32	✓			
30°	± .05° $\pm .05°$	30°	✓			
R0.25	$\pm .030$.25	✓			
Ø0.386	$\pm .005$ $- .001$.387	✓			
R0.62	$\pm .030$.620	✓			
0.40	$\pm .030$.415	✓			
0.20	$\pm .030$.200	✓			
R0.50	$\pm .030$.500	✓			
1.600	± .010 $\pm .010$	1.600	✓			
2.700	$\pm .010$	2.705	✓			
0.625	$\pm .010$.626	✓			
1.250	$\pm .010$	1.252	✓			
0.12 x 45°	$\pm 0.030 / \pm 1/2°$	0.165 x 45°	✓			
24.100	$\pm .010$	24.100	✓			
12.050	$\pm .010$	12.05	0			
R0.265	± 0.010	0.265	✓			
0.82	$\pm .030$.823	✓			
1.745	± 0.010	1.746	✓			Moyenne d 2 side.
R.0.18	± 0.030	0.180	✓			
10°	$\pm 1/2°$	10°	✓			
1.120	± 0.010	1.120	✓			
R.0.25	± 0.030	0.250	✓			
R.1.00	± 0.030	1.000	✓			

Measured by: DP/	Audited by: SLS	Prototype Approval:
Date:	Date: 08/04/18	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	40938
Description: Rappel Slide Bar		Part Number:	D3011-1
Inspection Dwg:	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: DIP/JL	Audited by:	Prototype Approval:
Date: 18/08/11	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	